Qty -031	Qty -032	Part Number	Description
Χ		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	Х	D412-630-032	PILOTICO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

^{*} USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024TM HELI-ACCESS-STEP

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

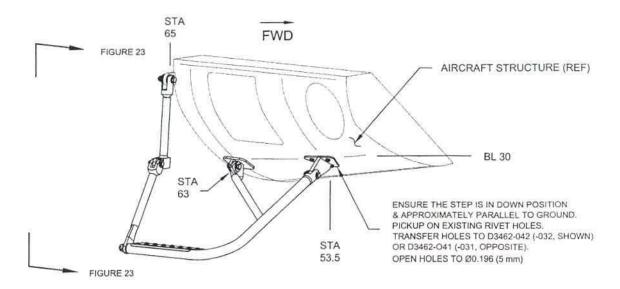


FIGURE 21 - Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown), D412-630-031 LH (Opposite)

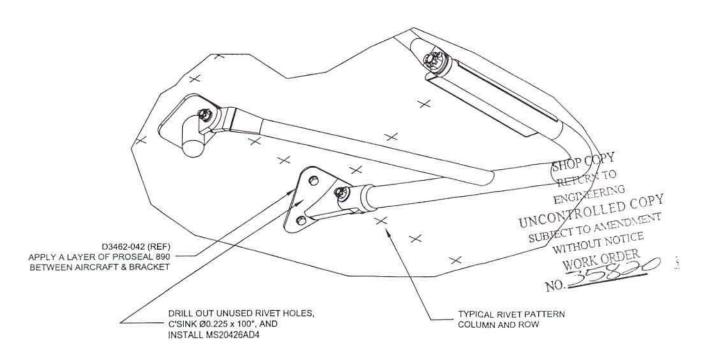


FIGURE 22 - Detail View D3462-042 Bracket Assembly (-032 Installation, Shown) D3462-041, (-031 Installation Opposite)

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> L Revision:

> > 07.09.30

Date:

Monday, 11/19/2007 4:01:50 PM Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Job Number: 35820 Part Number: D412630032 Job Number: Seq. #: Machine Or Operation: Description: 37.0 QC4 INSPECT 100% KITS FOR COMPLETENESS oda Comment: INSPECT 100% KITS FOR COMPLETENESS 38.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-031 Location: PPP Rev: 39.0 68.02.13 Comment: FINAL INSPECTION/W/O RELEASE Job Completion 08:01.2 Ail 00/01/14 in 2008/2/12

WUTUAY, 11/10/2001 7.01.00 1 W Dale. Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Seq. #: Machine Or Operation: WASHER AN960C516 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Qty Part Number Description M102842 AN960C516 Washer Nut MS210433 33.0 Total: 9.0000 Each(s) Comment: Qty.: 3.0000 Each(s)/Unit Pick: Description Part Number Qty 4105792 MS21043-3 Nut COTTER PIN MS24665227 34.0 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Comment: Qtv.: Pick: Description Qty Part Number M106043 COTTER PIN MS24665-227 COTTER PIN MS24665229 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Comment: Qty.: Pick: Batch MIGOGL Description Part Number Qty COTTER PIN 2 MS24665-229 Washer NAS1515H5 36.0 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Description Part Number Qty M1003.03 NAS1515H5 Washer 8/2/8 50

Monday, 11/19/2007 4.01.00 F.W. Date: Kim Johnston **Process Sheet** User: Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Machine Or Operation: Seq. #: AN3-C5A Bolt 3 eyebolt AN44C12 27.0 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: M106297 SP Description Batch Part Number Qty Eyebolt AN44-C12 BOLT AN4C15 28.0 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Description Part Number Qty M103348 BOLT AN4C15 1 AN5C11 29.0 3.0000 Each(s) 1.0000 Each(s)/Unit Comment: Qty.: Total: Pick: Description Part Number Qty 4103248 BOLT 1 AN5C11 BOLT AN5C15 30.0 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Description Qty Part Number MO5/60 BOLT AN5C15 1 WASHER AN960C10 31.0 21.0000 EACH(s) Total: Comment: Qty.: 7.0000 EACH(s)/Unit Pick: Part Number Description Qty 1106302 Washer AN960C10

Page 6

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Date: Monday, 11/19/2007 4:01:50 PM User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 35820 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: 21.0 D34551 Spacer Comment: Qty.: 18.0000 Each(s) Total: 6.0000 Each(s)/Unit Pick: Description Part Number Qty 328771 6 D3455-1 Spacer D34553 Spacer 22.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Qty Part Number Description Batch D3455-3 Spacer 2 D3462042 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Batch 36454 Description Part Number Qty D3462-042 Bracket ass'y NUT 24.0 AN3104 Comment: Qty.: 1.0000 Each(s)/Unit 3.0000 Each(s) Total: Pick: MIOSA80 Qty Part Number Description AN310-4 Nut 25.0 AN3105 Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Qty Description Part Number M105280 2 AN310-5 Nut 26.0 AN3C5A 410657 \$ Comment: Qty.: 9.0000 Each(s) 3.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Batch Page 5

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			Ti I						

Monday, 11/19/2007 4:01:50 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Seq. #: Machine Or Operation: Cotter Pin 15.0 MS24665302 Comment: Qty.: 3.0000 Each(s) Total: 1.0000 Each(s)/Unit Pick: Part Number Description Qty M106163 MS24665-302 COTTER PIN 1 INSPECT WORK TO CURRENT STEP QC5 16.0 Comment: INSPECT WORK TO CURRENT STEP ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. PACKAGING RESOURCE #1 PACKAGING 1 17.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit 18.0 D34541 Bushing Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Description Qty Part Number D3454-1 1 Bushing D34543 19.0 Comment: Qty.: Total: 6.0000 Each(s) 2.0000 Each(s)/Unit Pick: Qty Part Number Description 335171 D3454-3 Bushing 2 D34545 Bushing 20.0 6.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: Qty Part Number Description 2 D3454-5 Bushing

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Monday, 11/19/2007 4:01:50 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Seq. #: Machine Or Operation: NUT AN3104 10.0 Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Qty Part Number Description M105280 AN310-4 Nut 1 COTTER PIN 11.0 MS24665227 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: MIOGO (3 Description Qty Part Number MS24665-227 COTTER PIN 1 Seo Spacer 12.0 D34551 Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Description Qty Part Number 2 D3455-1 Spacer 13.0 D34651 Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Description Qty Part Number 1 D3465-1 Washer 140 AN3107 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Part Number Description Qty AN310-7 Nut

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Monday, 11/19/2007 4:01:50 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 35820 Job Number: Description: Seq. #: Machine Or Operation: D3443041 Strut Weldment Assembly 5.0 Comment: Qty.: 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Description Qty Part Number D3443-041 Strut ass'y 1 6.0 D34439 Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: M30228 Part Number Description Qty 2 D3443-9 Pin SS Bolt 7.0 AN4CH3 Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Part Number Description Qty 2 AN4CH3 BOLT A/R MS20995c41e Lockwire BOLT 8.0 AN4C14 Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s) Pick: Qty Part Number Description 1103248 BOLT AN4C14 1 90 D34547 Bushing Comment: Qty.: 6.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: M35634 Description Qty Part Number 8/1/24 50 2 D3454-7 Bushing Form mrocess Page 2

Monday, 11/19/2007 4:01:50 PM AUT Process Sheet Date: Kim Johnston User. * : PILOT/CO-PILOT STEP, RH (FOLDING) Drawing Name ·: CU-DAR001 Dart Helicopters Services Customer : 35820 -7 Job Number : 10824 Estimate Number Part Number : D412630032 P.O. Number · IIN D412-630 **Drawing Number** : 11/19/2007 S.O. No. : This Issue · N/A : NC Project Number Prsht Rev. : 11 Type : LARGE FAB ASSY Drawing Revision : L First Issue . 34836 Material Previous Run Each : 12/12/2007 Due Date Um: Written By Checked & Approved By : EST. REV. A 05.11.21 **NEW ISSUE** EC Comment EC updated pick list EST. REV. B 05.12.19 EC EST. REV.C 07.11.12 ecn 1019, nochg verifiedby:DD Additional Product Job Number: Description: Machine Or Operation: Seq. #: DOCUMENT CONTROL DC 1.0 08/12/4 Comment: DOCUMENT CONTROL 07.11.299 Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001 SMALL & MEDIUM FAB RESOURCE 1 2.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.17 ****ensure tension to retract step is 11 to 18 lbs before installing lockwire.**** Step Weldment D3463042 3.0 3.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Part Number Description Qtv Step weldment D3463-042 Strut Weldment Assembly D3443043 40 3.0000 Each(s) Total: Comment: Qty.: 1.0000 Each(s)/Unit Pick: Batch Description Part Number Qty D3443-043 Strut ass'y